

5126486



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

647.3915E
Job Sheet 163053



Part No: 647.3915E

Job Qty: 50 ea

Part Name: Deflector



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 9/30/17

Job Tracking No:

Due Date: 12/1/17

Created By: Mario Poulin

Type: Stock

Description:

Note: DWG REV C2 IPP REV:A NEW ISSUE 14-04-22 JLM VERIFIED BY:DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Purchasing	50 pcs		12/1/17	0.00	0.00	Purchasing		AT 18/11/09
110	Packaging	50 pcs		12/1/17	0.00	0.00	Packaging2		AT 18/11/09
120	QC	50 pcs		12/1/17	0.00	0.00	QC18		AT 18/11/09
130	Packaging	50 pcs		12/1/17	0.00	0.00	Packaging3		M.F 18-11-14
140	QC21-SA	50 Ea		12/1/17	0.00	0.00	QC21		DAS 21 NOV 15 2018

Part Op 110 - Receive & Inspect for Damage & Mat'l Certs

Descriptions: 120 - QC18 In-Coming Inspection Material

130 - Identify as per dwg & Stock Location: MAT036

140 - QC21- Final Inspection - Work Order Release

APR 27 2018

P/O: 39723

X50pcs

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
647.3915P	Deflector (DIE#7B1894)	50 ft (1 ea)	100-Purchasing	5119261

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Purchasing	647.3915P	50	0	0

Part Specifications

Specifications could not be found.

Plex 4/26/18 12:19 PM dart.lavoie.chantal

P.T.O.

NOV 1 1955

NOV 1 1955

NOV 1 1955



APICAL INDUSTRIES, INC.
dba DART AEROSPACE

TRANSACTION CODES (TC):
A-ADD C-CREATE
R-REVISE D-DELETE

ENGINEERING CHANGE NOTICE NO. 04948

SHEET 1 OF 2

DWG NO. 647.3900

REV: C

PREPARED BY: M. ANDECK

DATE: 05/04/15

EFFECT ON DWG
☐ INC. ☒ UNINC.

DWG TITLE: DEFLECTORS

APPROVED BY:

ENGR

Brans

MFG

Dave Dade

QC

Bill

EFF:

CURRENT ORDER

ECR:

D-15-01

REASON: REVISED TOLERANCE AND NOTES

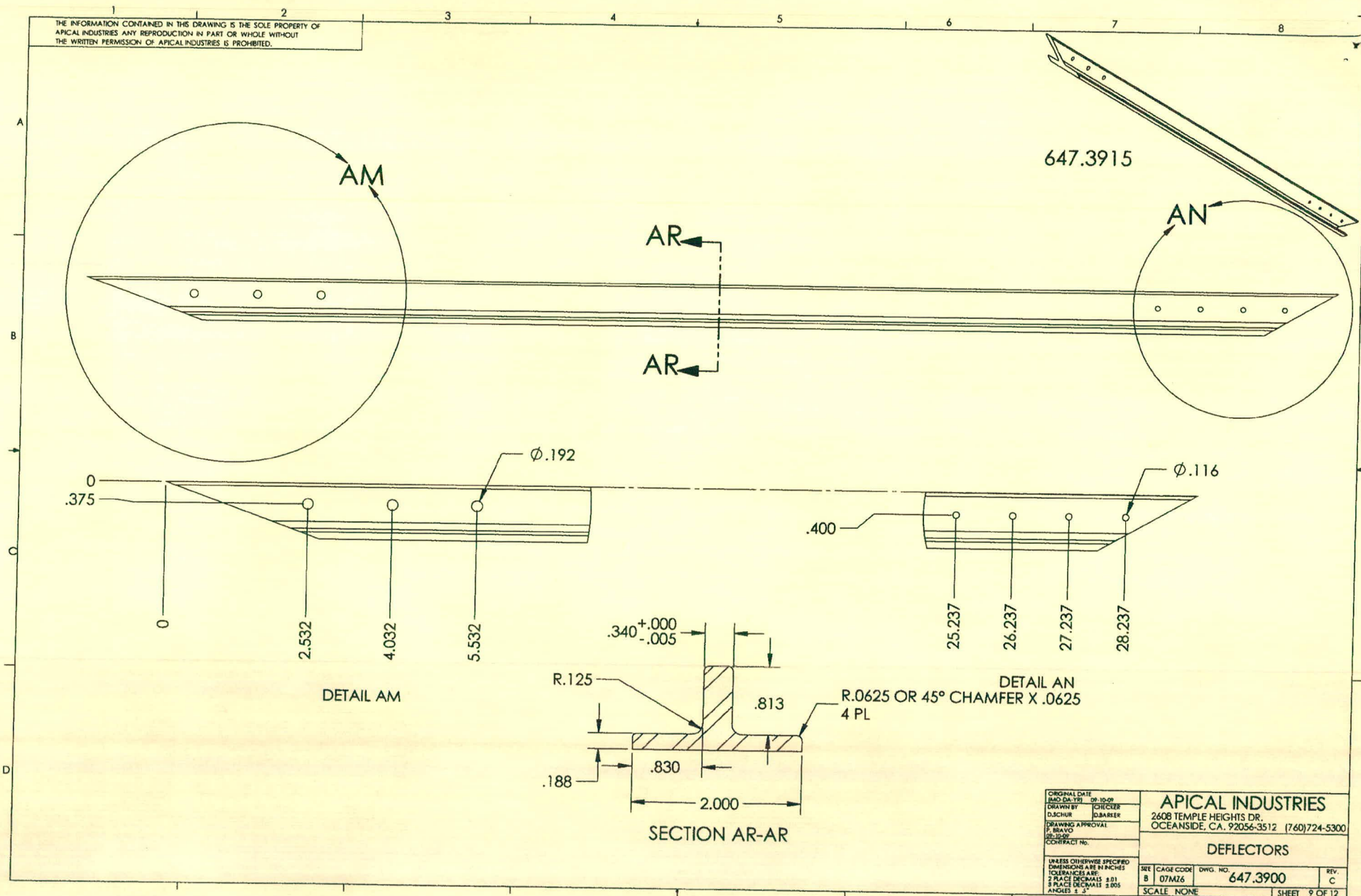
NOTES:

- 1 MATERIAL: ALUMINUM 7075-T651 PER AMS-QQ-A-250/12.
- 2 FINISH: HARD ANODIZE IAW MIL-A-8625 TYPE III, CLASS 2, COLOR BLACK;
3. DEBURR AND BREAK ALL SHARP EDGES.
4. IDENTIFY IAW MPP-120.
- 5 APPLY F/N, 3 AS REQUIRED TO ALL FAYING SURFACES OF F/N 6, 7 & 8 UPON ASSY.
- 6 MAXIMUM OR MINIMUM DIMENSION AFTER FINISH.
7. .0625 HOLE MAY BE ADDED FOR FINISHING PURPOSES
- 8 FINISH: PRETREAT PR-148 ADHESION PROMOTER, PRIME IAW MIL-P-23377J, TYPE I, CLASS N; 1-2 MIL MAX. APPLY FINISH AFTER ASSEMBLY.
- 9 FINISH: PRETREAT PR-148 ADHESION PROMOTER, PRIME IAW MIL-P-23377J, TYPE I, CLASS N; 1-2 MIL MAX.
- 10 MATERIAL: ALUMINUM 2024-T3 PER AMS-QQ-A-250/4.

SHEET 1, ZONE B1 IS:

11	R	647.3917	2				DOUBLER		
F/N	TC	PART NUMBER	.3903	.3902	.3901		DESCRIPTION	MATERIAL	SPECIFICATION
			QTY						
DOCUMENTS EFFECTED:							CHANGE CATEGORY	DER REVIEW REQUIRED	
☐ PATTERN ☐ MDL ☐ INSTALL INSTRU ☐ ICA ☒ BOM							☐ MAJOR ☒ MINOR	☐ YES ☒ NO	

THE INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF
APICAL INDUSTRIES ANY REPRODUCTION IN PART OR WHOLE WITHOUT
THE WRITTEN PERMISSION OF APICAL INDUSTRIES IS PROHIBITED.



ORIGINAL DATE (MO-DA-YR) 08-10-09		APICAL INDUSTRIES	
DRAWN BY D.SCHUR		2608 TEMPLE HEIGHTS DR.	
CHECKED BY D.BARKER		OCEANSIDE, CA. 92056-3512 (760)724-5300	
DRAWING APPROVAL P. BRAYO		DEFLECTORS	
CONTRACT NO.		647.3900	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS $\pm .01$ 3 PLACE DECIMALS $\pm .005$ ANGLES $\pm .5^\circ$		SHEET B	REV. C
SCALE NONE		DWG. NO. 07M126	SHEET 9 OF 12



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613).632-5200

PURCHASE ORDER **PO039723**

Supplier: UNA001-VU
Universal Alloy Corporation
2871 La Mesa P.O. Box 6316
Anaheim, CA 92816-8316 USA
Phone: 714-630-7200
Fax: 714-630-7207

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: PO039723

PO Date: 4/27/18

Due Date: 7/25/18

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Lavoie, Chantal
clavoie@dartaero.com

Via: Ground

Pymt Terms: COD

Freight Terms:

Special Comments: QUOTE NO. 398884

E-MAILED
APR 27 2018

Items

Line Item	Part	Supplier Part No	Item No	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (USD)	Extended Price
1	647.3915P			Deflector (DIE#7B1894) receive pcs	Firmed	7/25/18	50 Ea	0 Ea	50 Ea	\$30.56/Ea	\$1,528.00

Line Item Note AS PER DWG 647.3900 REV. C
WO 163053

Grand Total: \$1,528.00

Order Notes

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Procurement Quality Clauses

A005 RIGHT OF ENTRY

A007 FIRST ARTICLE INSPECTION (FAI) BY SELLER, (DOCUMENTATION MAINTAINED BY SUPPLIER)

A012 CHEMICAL AND PHYSICAL TEST REPORTS

A016 PERSONNEL QUALIFICATION

A017 RAW MATERIAL IDENTIFICATION (AS APPLICABLE)

A026 CERTIFICATION OF MATERIAL CONFORMANCE

A041 QUALITY MANAGEMENT SYSTEM

A042 DART NOTIFICATION BY SUPPLIER

A043 RETENTION OF QUALITY DOCUMENT

A048 COUNTERFEIT PARTS AVOIDANCE, DETECTION, MITIGATION AND DISPOSITION PROGRAM

A049 SUPPLIER AWARENESS

CL
ON

Plex 4/27/18 8:25 AM dart.lavoie.chantal

SHIPPER NO.

544582-1

UACPART NO.

67658

UNIVERSAL ALLOY CORPORATION

2871 JOHN BALL WAY, P.O. BOX 6316, ANAHEIM, CA USA 92816-6316
(714) 630-7200 (800) 331-7772 FAX (714) 630-7207

PRODUCTION LOTS

A795485 @56 PCS

SHIP
PART

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY, ONTARIO CN, K6A 1K7

SHIP
PART

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY, ONTARIO CN, K6A 1K7

32/320

CUSTOMER'S P.O. NO.

PO039723 item 1

ORDER PLACED BY

CHANTAL LAVOIE

CUSTOMER'S PART NUMBER

647.3900 647.3915P

ALUMINUM EXTRUSION

TERMS

NET 60

ALLOY

7075 T6511

SPECIFICATION NO.

AMS-QQ-A-200/11 REV. A

SHIP VIA

ECCN#

DATE SHIPPED

10/05/2018

FREIGHT CHARGES

PREPAID ☒ COLLECT ☐

SHIPMENT

PARTIAL ☐ COMPLETE ☒

CERTIFICATIONS

ATTACHED ☒ TO FOLLOW ☐

QUANTITY SHIPPED

FEET	PIECES X LENGTH	NET PER PC	NET POUNDS	GROSS POUNDS	BOX
140	56 X 30.	2.02	113	126	1 bundle of 1 fiber board with plywood caps box
RECEIVED BY X		DATE	TIME		

UNIVERSAL ALLOY CORPORATION ACCEPTS NO RESPONSIBILITY FOR ERROR IN SHIPMENT IF YOU FAIL TO NOTICE US WITHIN 3 DAYS OF RECEIPT. NO REJECTED MATERIAL WILL BE ACCEPTED FOR CREDIT OR REPLACEMENT AFTER 30 DAYS FROM DATE OF RECEIPT.

THIS SUPPLIER HAS BEEN DELEGATED BOEING INSPECTION AUTHORITY FOR ALL PARTS MANUFACTURED UNDER CONTRACT WITH THE BOEING COMPANY.

SHIPPER NO.

544582-1

UACPART NO.

67658

UNIVERSAL ALLOY CORPORATION

2871 JOHN BALL WAY, P.O. BOX 6316, ANAHEIM, CA USA 92816-6316
(714) 630-7200 (800) 331-7772 FAX (714) 630-7207

PRODUCTION LOTS

A795485 @56 PCS

SHIP
PART

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY, ONTARIO CN, K6A 1K7

SHIP
PART

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY, ONTARIO CN, K6A 1K7

32/320

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647.3900 647.3915P

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SHIP VIA

ECCN#

DATE SHIPPED

10/05/2018

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PREPAID ☒ COLLECT ☐

SHIPMENT

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CERTIFICATIONS

ATTACHED ☒ TO FOLLOW ☐

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**EXTRUSION MILL CERTIFICATE OF CONFORMANCE**

Inspection & Test Report

Page 1 / 1

Customer	DART AEROSPACE LTD, 1270 ABERDEEN		
Certificate Date	09/06/2018	Purchase Order	PO039723 / 1
Material	7075	Order Number	544582
Temper	T6511	Part Number	647.3900 Rev. C / 647.3915P
Specification(s)	AMS-QQ-A-200/11 REV. A		

Chemical Composition Limits		Si	Fe	Cu	Mn	Mg	Cr	Zn	Ti	Others	
										Each	Total
*Remainder aluminium	Min	0.0	0.0	1.2	0.0	2.1	0.18	5.1	0.0		
	Max	0.40	0.50	2.0	0.30	2.9	0.28	6.1	0.20	0.05	0.15

Tensile Test Results				UTS	TYS	Elongation
Lot No.	Temper	Orient.	Location	ksi	ksi	%
A795485	T6511	L	Rear	90.9	81.4	11.0

Additional Information

This is to certify that material applied to the above order covered by this test report has been inspected in accordance with the specifications and drawing forming a part of this order and complies with the contract. Representative material has been tested and found to meet the applicable requirements. Further shown are the composition limits and laboratory test results. Documentation verifying conformance to these requirements is on file and available for review.

UNIVERSAL ALLOY CORPORATION

2871 John Ball Way

Anaheim, CA 92806

Mike Simon Metallurgical Lab Supervisor
QUALITY ASSURANCE DEPARTMENT

Lab Approval



795485T04

COUNTRY OF MELT & MANUFACTURE - U.S.A.
Rev. 04/18/2016

MATERIAL RECEIPT INSPECTION FORM

MATERIAL: 647.3915E
DATE: 18/10/17

PO / BATCH NO.: P0039723/5126486
~~5119261~~

MATERIAL CERT REC'D: Kes
QUANTITY RECEIVED: 56x
QUANTITY INSPECTED: 56x
QUANTITY REJECTED: 0

THICKNESS ORDERED: 2.000"
THICKNESS RECEIVED: 2.000"
SHEET SIZE ORDERED: -
SHEET SIZE RECEIVED: -

DESCRIPTION	NCR (Check Y/N)		COMMENTS
SURFACE DAMAGE	Y	☒ N	
CORRECT FINISH	☒ Y	N	
CORROSION	Y	☒ N	
CORRECT GRAIN DIRECTION	☒ Y	N	
CORRECT MATERIAL PER M-DRAWING	☒ Y	N	AMS-20-A-200/11 (see attached)
CORRECT THICKNESS	☒ Y	N	
PHOTO REQUIRED	Y	☒ N	
CORRECT REF # TO LINK CERT	☒ Y	N	P0039723
CORRECT MATERIAL IDENTIFICATION	☒ Y	N	
CORRECT M# ON THE MATERIAL	☒ Y	N	
DOES THIS MATERIAL REQUIRE ENGINEERING SIGN OFF	Y	N	
DOES THIS REQUIRE AN EXTRUSION REPORT	Y	☒ N	

CUT SAMPLE PIECE OF MATERIAL AND PREFORM A HARDNESS CHECK. RECORD RESULTS BELOW					
TYPE OF MATERIAL	HRC	HRB	DUR A	DUR D	WEBSTER
SIZE OF TEST SAMPLE					
HARDNESS / DUROMETER READING					

testers located in the Quality Office

QC 18 INSPECTION		ENGINEERING SIGNOFF (if required)	
INSPECTED BY: <u>AI</u>	SIGNED OFF BY: <u>acceptable as per</u>		
DATE: <u>18/10/17</u>	DATE: <u>attach Email.</u>		

Attach this inspection sheet with the corresponding material cert and remit to be scanned and received in

Patrick Duval

From: Pablo Bravo
Sent: Wednesday, November 07, 2018 3:36 PM
To: Chantal Lavoie
Cc: Linda Lacelle; Patrick Duval; Robert Aboud
Subject: RE: mat'l spec's

Chantal,

You can use the 200/11.

PABLO BRAVO

Director of Engineering – San Diego

DART AEROSPACE

T 1 760 724-5300 > 106

O 1 760 509-1606

F 1 760 509-1562

1 800 556- 4166

www.dartaerospace.com

From: Chantal Lavoie
Sent: Wednesday, November 7, 2018 6:30 AM
To: Pablo Bravo <pbravo@dartaero.com>
Cc: Linda Lacelle <llacelle@dartaero.com>; Patrick Duval <pduval@dartaero.com>; Robert Aboud <raboud@dartaero.com>
Subject: mat'l spec's

Good morning Pablo,
Will need your help on the following dwg. I have place an order for 647.3915 on the dwg it's asking for AMS-QQ-A-250/12 but rec'd AMS-QQ-A-200/11.
Please advise if this would be acceptable.
Thanks
Chantal

Chantal Lavoie

Purchasing Coordinator

DART AEROSPACE

T 1 613 632-5200

F 1 613 632-1053

E clavoie@dartaero.com

1 800 556- 4166

www.dartaerospace.com



